


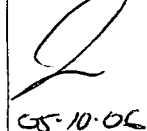
DART AEROSPACE LTD	Work Order:	24148
Description: Wearshoe	Part Number:	D2656-35
Drawing: D2656 Rev. <i>20</i>	Qty:	50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	U	05-09-02	50
2	PG	Issue P/O: <u>2008582</u> Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-35 Material release note required	U	05-09-02	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CL	05/09/20	50
4	QC6	Inspect dimensions per template D2656-35T1	J	05-10-06	49
5	GB	Deburr if necessary	N/A		
6	GB	Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-35.	SB	05/11/15	49
7	QC5	Inspect work to Step 6	J	05-11-16	49
8	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	FL	06-01-12	49
9	QC3	Inspect Powder Coat	CL	06/01/13	49
10	FP	Identify and Stock	CL	06/01/13	49
11	AC	Cost / part:	U	06-01-13	49
12	DC	Close W/O Inspect Level 21	CL	06/01/16	49


PTO

Rev	Date	Change	Revised By	Approved
A	97.12.04	New Issue		
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for powder coat – in house process	EC	
D	02.10.25	Re-format	KJ RF	SA

RELEASED
02/10/30 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-10-06	6	destroy old template And Identify new template wearplate (REV. E) AS D2565-35 T1. Inspected dimensions And they're good.		05-10-06	1	CP 05-10-06 per QSA 642	 05-10-06	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/01/16

NOTE: Date & initial all entries

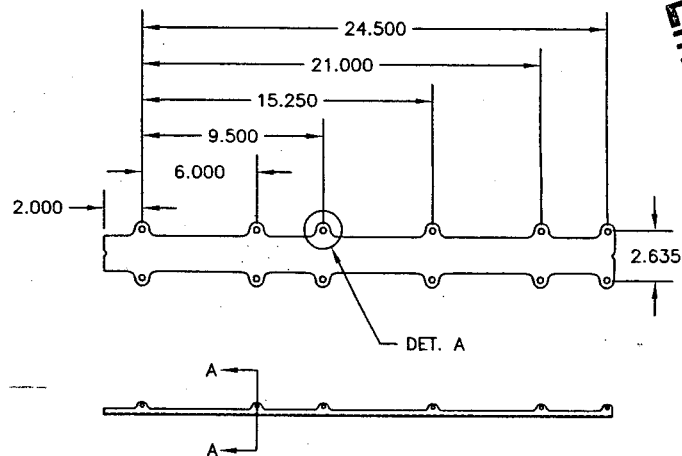
QA: N/C Closed: _____ Date: _____



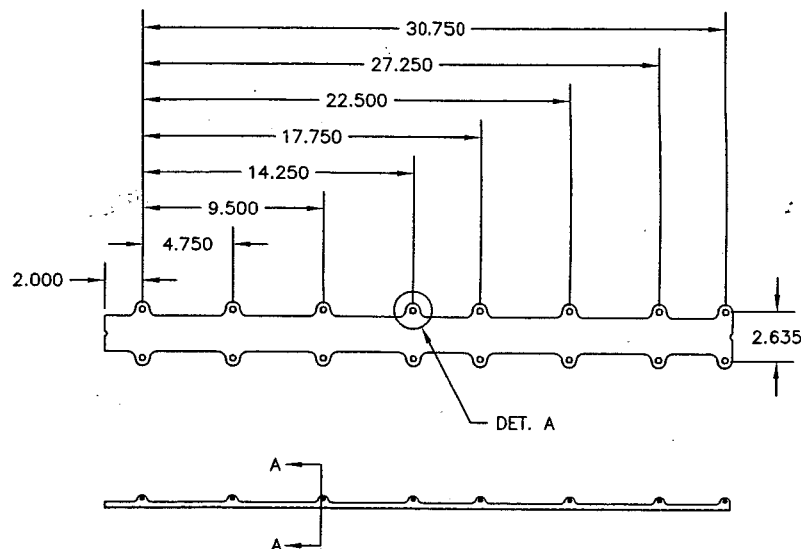
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	DRAWING NO.	REV. D
05.08.17	D2656	SHEET 3 OF 4
	TITLE	SCALE
	WEARSHOE	1:10

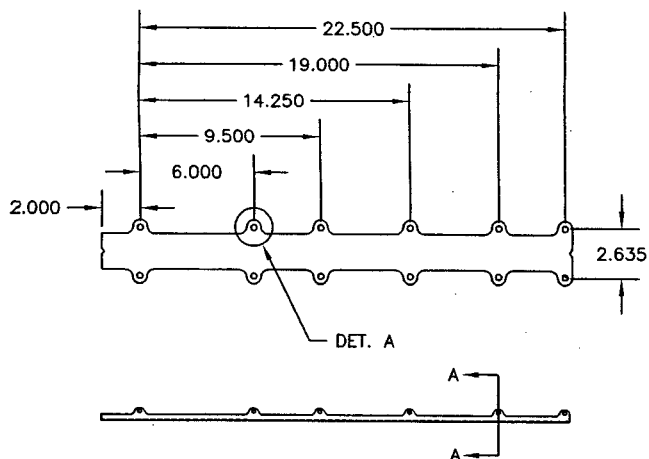
D2656-33



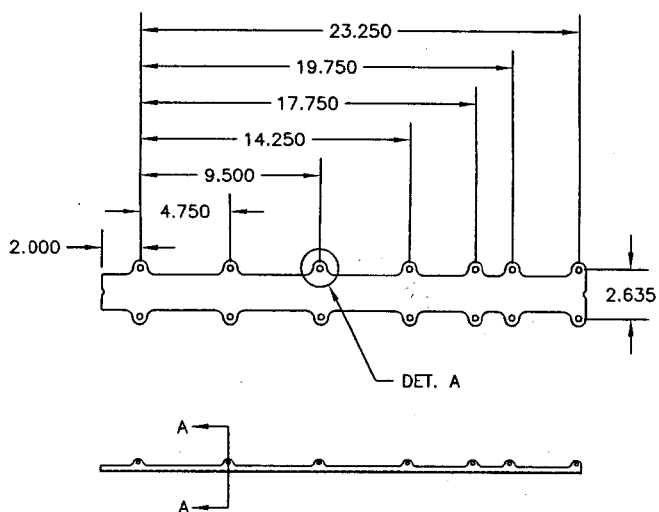
D2656-37



D2656-31



D2656-35



NOTES

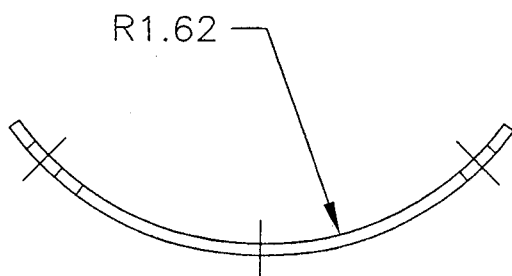
MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



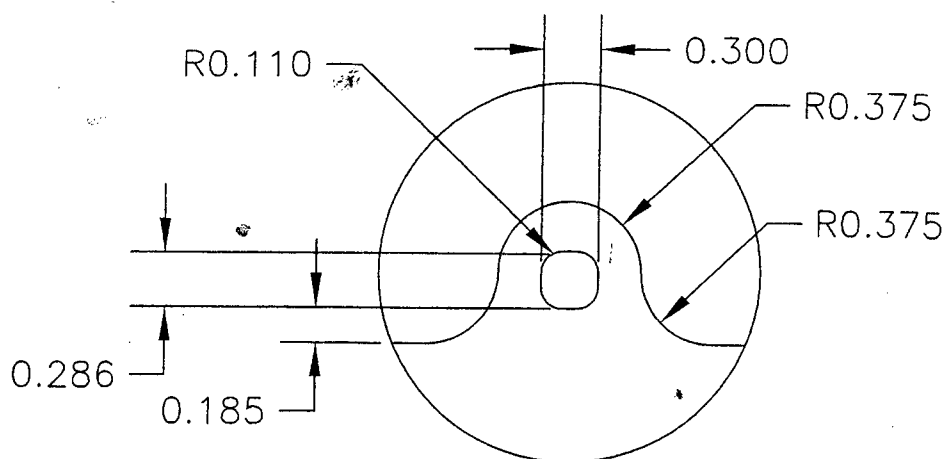
PRELIMINARY ISSUE

DESIGN	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

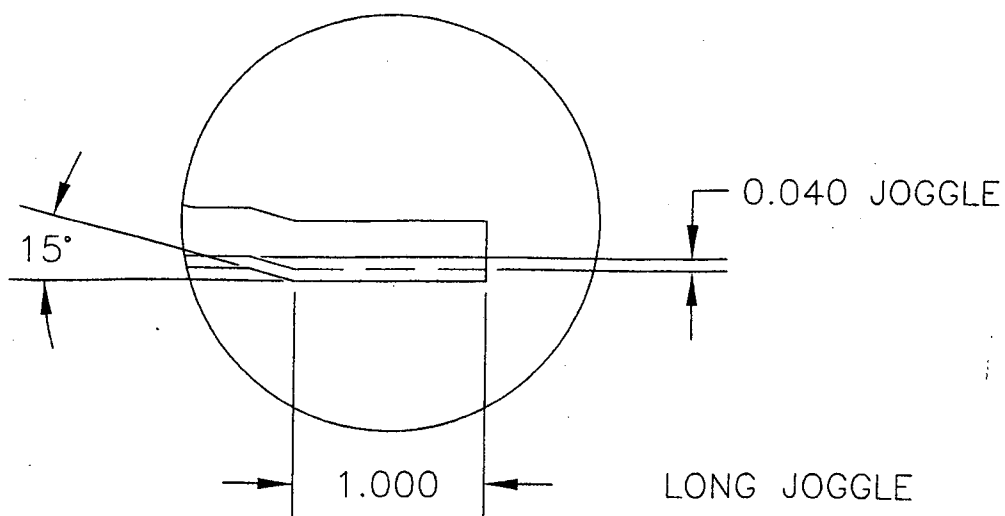
SECTION A-A



DETAIL A

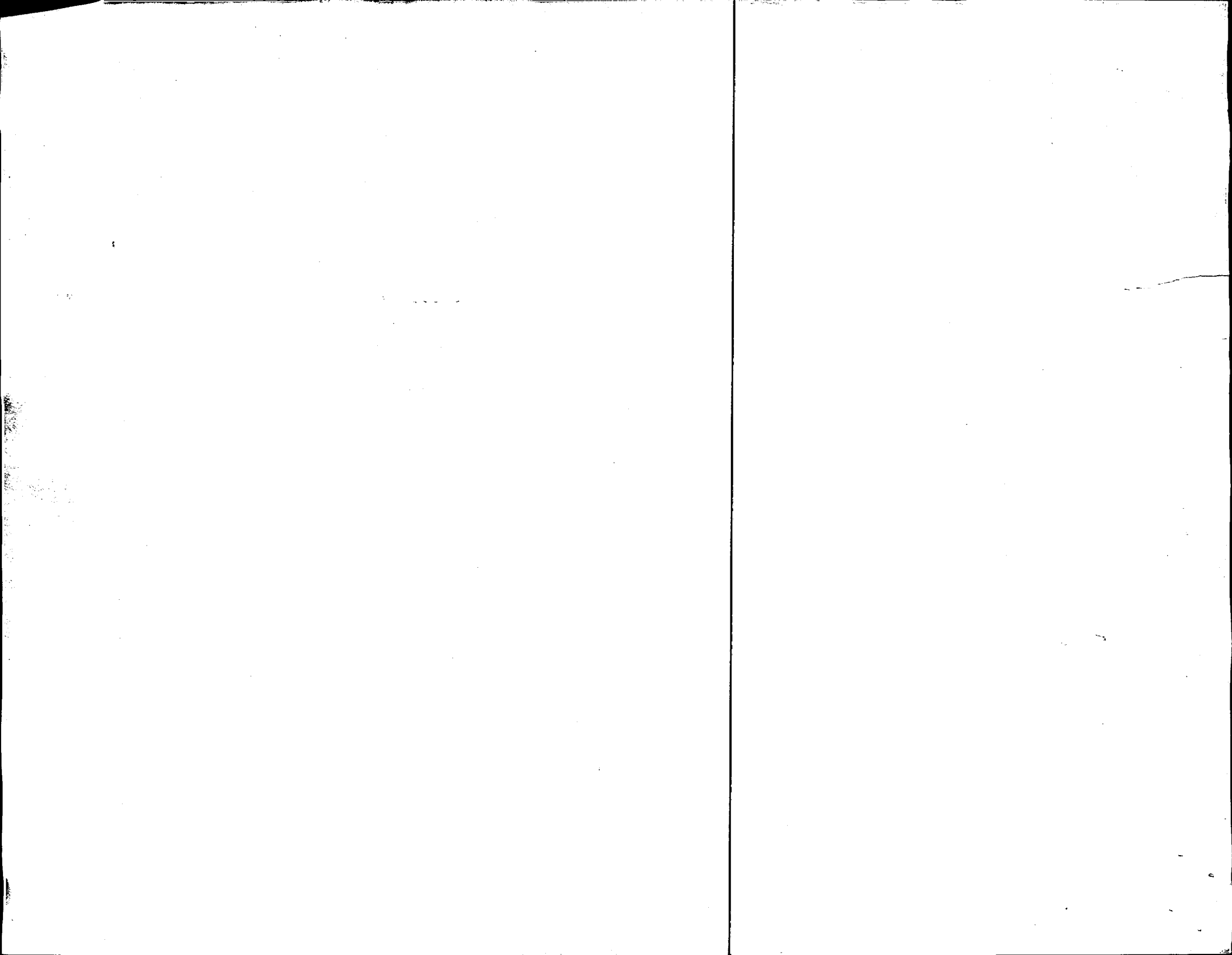


DETAIL B



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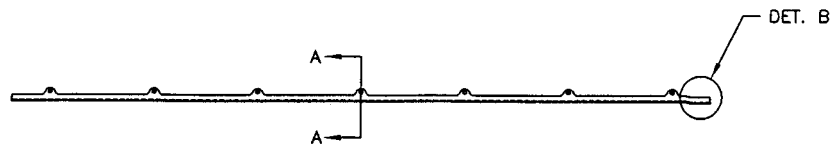
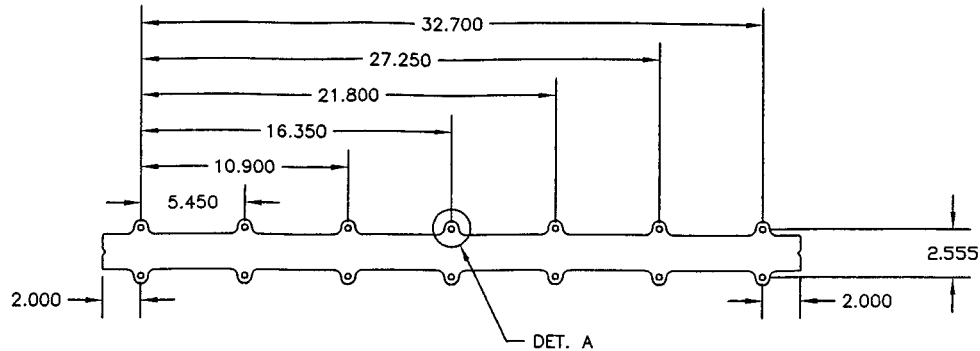




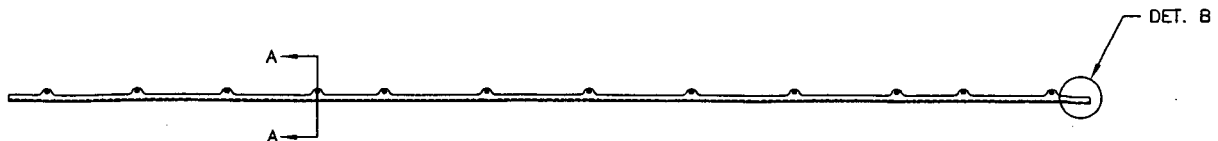
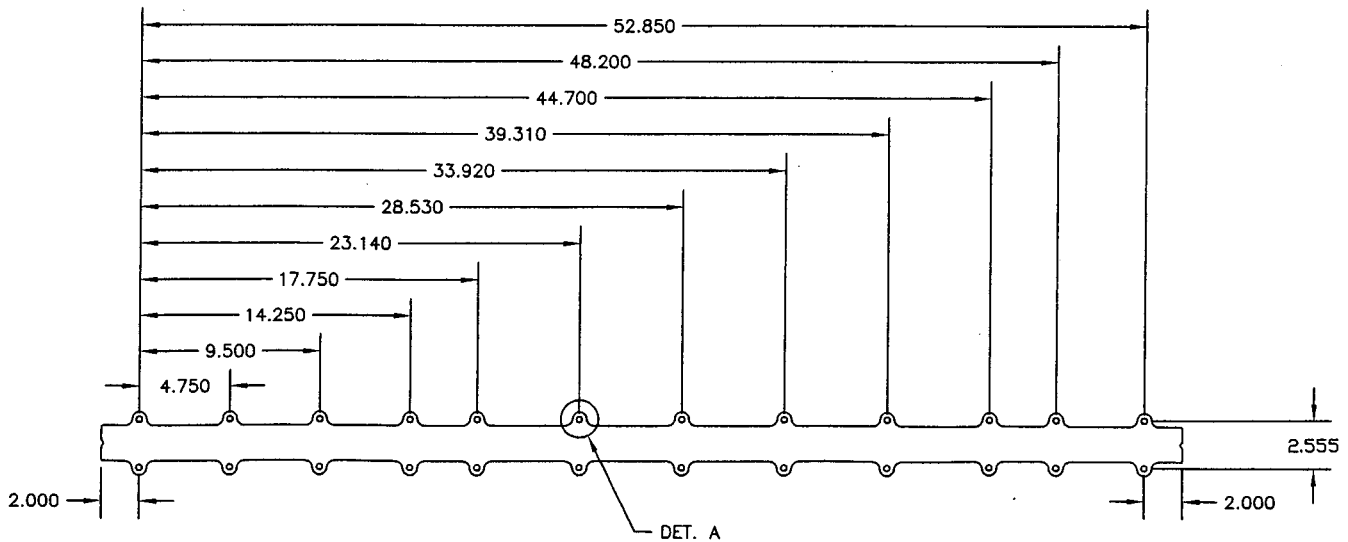
PRELIMINARY ISSUE

DESIGN	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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30. 11. 1900

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 01, 2005
10:48 am

Work Order No : 0024148
Project Name : D2656-35
Project For : WK537
Work Order Type : Main
Main WO Number :
House Part Number : D2656-35
Description : Wearplate
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 08-29-05
Est Finish Date : 09-16-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 62121, Auckland, New Zealand
Telephones: (09) 375 8888 / 375 8111 Auckland
(09) 235 8088 / 235 3535 Waiuku
Fax: (09) 375 8858

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER		Wilkinson		P41007PI002										SPECIFICATION										ASTMA1008 CS Type A										CERTIFICATE No										TC107796									
CUSTOMER O/N		90-21N-288												PRODUCT										CRA WIDE COIL										PAGE										1 of 1									
MILL O/N		453665												DIMENSIONS										0.033" x 48" x Coil										DATE										31 March 2005									
PACK NUMBER		HEAT No		CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)																																	
				C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH																											
				x100				x1000												x10000				x100				180°				G.L.=	HRB	()	(feet)																		
R9-455932-00		640077		5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621																											
R9-455933-00		640077		5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723																											
R9-455934-00		640077		5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546																											
R9-455935-00		640077		5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789																											

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.)			PLASTIC STRAIN RATIO (r)			IMPACT TEST			CARBON EQUIVALENT VALUE (CE)		
	(A)=200mm (B)=50mm	(C)=80mm (D)=5.65 ? So	(E)=2" (F)=8"	(A)=r0 (B)=r90	(C)=r45 (D)=(r0+r90+2r45) / 4		(A)=5mm x 5mm (B)=10mm x 10mm (C)=2.5mm x 10mm (D)=7.5mm x 10mm	(E)=5mm x 5mm (F)=2.5mm x 10mm (G)=5mm x 10mm		(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/8+S/24 (D)=	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Anish Misra*
QC METALLURGIST

20 GA CRMS

